

Work Order ID 73198

Friday, August 26, 2011 7:16:49 AM



Page 1

Item ID: D412-704-041

Accept



Setup Start



Revision ID:

Item Name: Pedal Assembly (205/212/214/412)

Stop



Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/26

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D412-704-041

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble pedal as per Dwg D412-704-041
Tighten & Torque Bolts as per Dwg D412-704-041

8/31/10/19 (4)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

5/11/19

(4)

120

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/10/19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				(+4)			
140 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PAP 73192	0.00 0.00							
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MF
11-10-20

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Picklist Print

Friday, August 26, 2011 7:16:46 AM

Page 1

Work Order ID: 73198

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)



Start Date: 8/26/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF
IPP Rev:C 06.03.08 Re-format EC
IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
IPP Rev:E 07.05.02 Reformat EC
IPP Rev:F 08-10-08 as per revB DD veriied by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			100	Each	104.0000	1	4			
<div><div><u>Location</u></div><div>ST351</div><div>117795</div></div> <div><div><u>Loc Qty</u></div><div>104</div><div>104</div></div> <div><div><u>Loc Code</u></div><div></div><div></div></div>													
AN315-4R Nut		Purchased	No			100	Each	45.0000	1	4			
<div><div><u>Location</u></div><div>ST324</div><div>17566</div></div> <div><div><u>Loc Qty</u></div><div>45</div><div>45</div></div> <div><div><u>Loc Code</u></div><div></div><div></div></div>													
AN4-10A Bolt		Purchased	No			100	Each	156.0000	1	4			
<div><div><u>Location</u></div><div>ST356</div><div>117313</div><div>117619</div></div> <div><div><u>Loc Qty</u></div><div>156</div><div>31</div><div>125</div></div> <div><div><u>Loc Code</u></div><div></div><div></div><div></div></div>													

Handwritten notes and signatures:

- Signature: *[Signature]* 8/24/10/19
- Text: 1119084 (42)
- Signature: *[Signature]* 8/24/10/19
- Text: 4
- Signature: *[Signature]* 8/24/10/19
- Text: 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 8/26/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-12A

Purchased

No

100

Each

228.0000

2

8



Bolt

Location

Loc Qty

Loc Code

ST357

228

112314

2

115422

26

117508

100

118628

100

AN4-13A

Purchased

No

100

Each

846.0000

1

4



Bolt

Location

Loc Qty

Loc Code

ST357

846

118078

594

118351

252

AN960JD10

NAS1149D0363J

Purchased

No

100

Each

0.0000

5

20



Washer

LD M117601 (20x)

AN960JD416

NAS1149D0463J

Purchased

No

100

Each

0.0000

11

44



Washer

LD M118612 (44x)

AN960JD416L

NAS1149D0416J

Purchased

No

100

Each

17.0000

3

12



Washer

Location

Loc Qty

Loc Code

FP-B

17

110153

17

M116513 (12x)

Friday, August 26, 2011 7:16:46 AM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 8/26/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

100

Each

1,783.000

1

4



Nut

Location

Loc Qty

Loc Code

ST300

1783

117441

150

117601

400

117885

233

118451

1000



EP 11/10/19

MS21042L4

Purchased

No

100

Each

4,143.000

5

20



Nut

Location

Loc Qty

Loc Code

ST300

4143

117441

57

117601

637

117885

1449

118451

2000



EP 11/10/19

MS24694-S102

Purchased

No

100

Each

40.0000

1

4



Screw

Location

Loc Qty

Loc Code

ST288

40

114382

40



EP 11/10/19

MS9519-10

Purchased

No

100

Each

28.0000

1

4



Bolt

Location

Loc Qty

Loc Code

ST296

28

100290

28



EP 11/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 8/26/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN3-6A
Bolt
Purchased No

120 Each 244.0000 2

Location

Loc Qty

Loc Code

ST351

244

117441

244

AN960JD10L
Washer
Purchased No

120 Each 0.0000 4

MS21042L3
Nut
Purchased No

120 Each 1,783.000 2

Location

Loc Qty

Loc Code

ST300

1783

117441

150

117601

400

117885

233

118451

1000

8

8

16

M117087

8

M118927

11/10/12

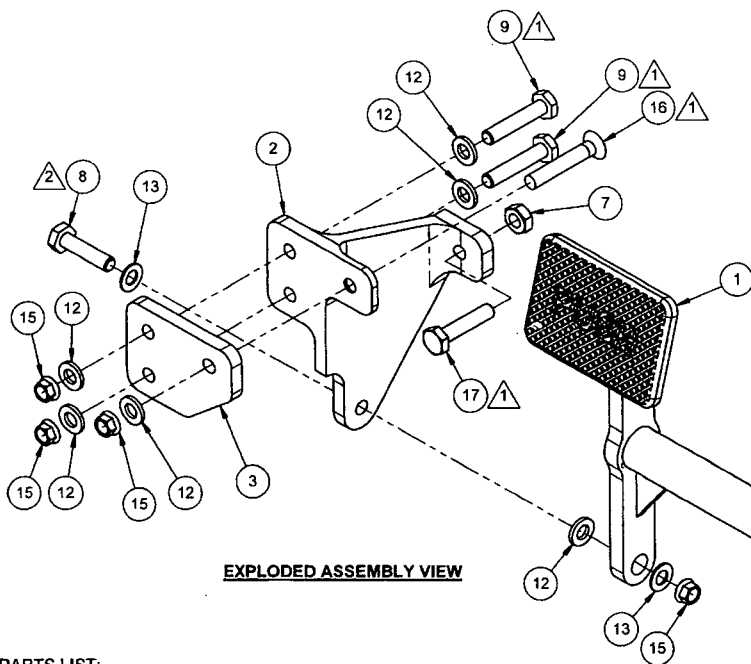
W/O:		WORK ORDER CHANGES					
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EXPLODED ASSEMBLY VIEW

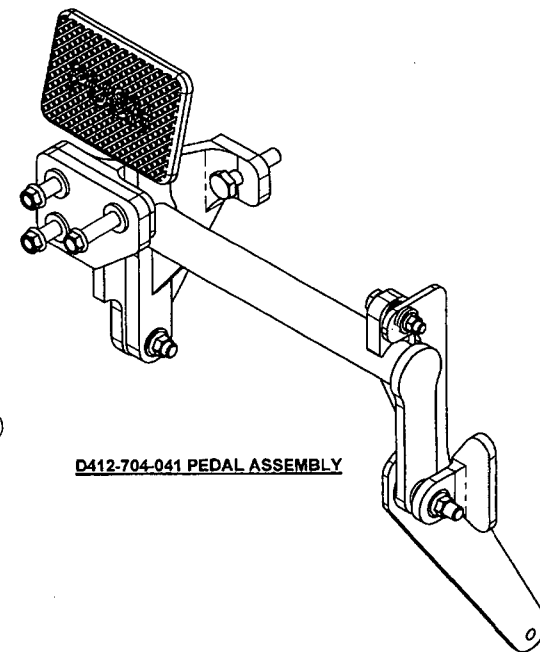
PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).



D412-704-041 PEDAL ASSEMBLY

RELEASED

07.01.23

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE		
DESIGN	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
CE	#	D412-704-041	SHEET 1 OF 1
DATE		TITLE	SCALE
07.01.23		PEDAL ASSEMBLY	1:2
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